

Date: Tuesday, 22/04/2008 3:53:07 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 A/B HIGH GEAR WEB
Job Number :	38746		
Estimate Number :	10455		
P.O. Number :		Part Number :	D26543
This Issue :	22/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2654 REV E1
First Issue :	/ /	Project Number :	N/A
Previous Run :	37764	Drawing Revision :	E1
	Type :	Material :	
	LANDING GEAR	Due Date :	05/05/2008
Written By :		Qty:	4
Checked & Approved By :	JLD 08.4.23	Um:	Each
Comment :	Est Rev:D 99.02.04 Fixed typo, Changed procedure DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	29985 SL 8-4-24

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-4-24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 38746

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-4-24

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

SL 8-4-24

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28

Job Completion



MF 08-04-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

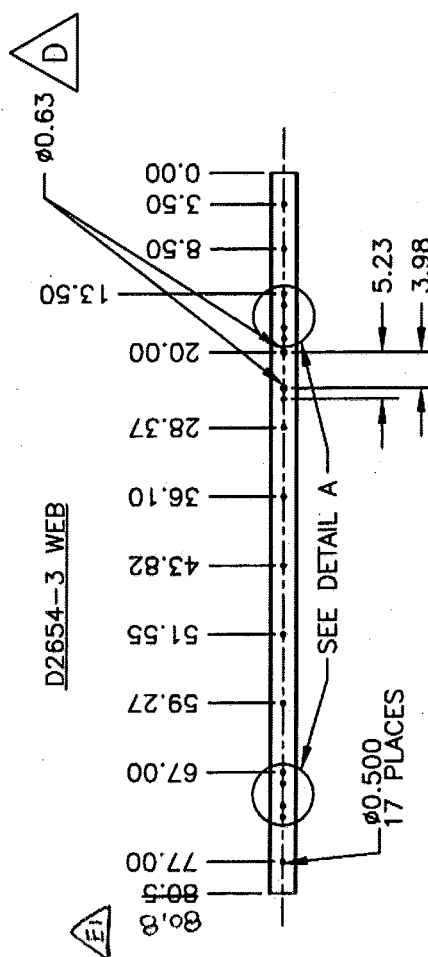
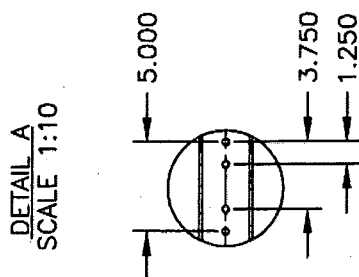
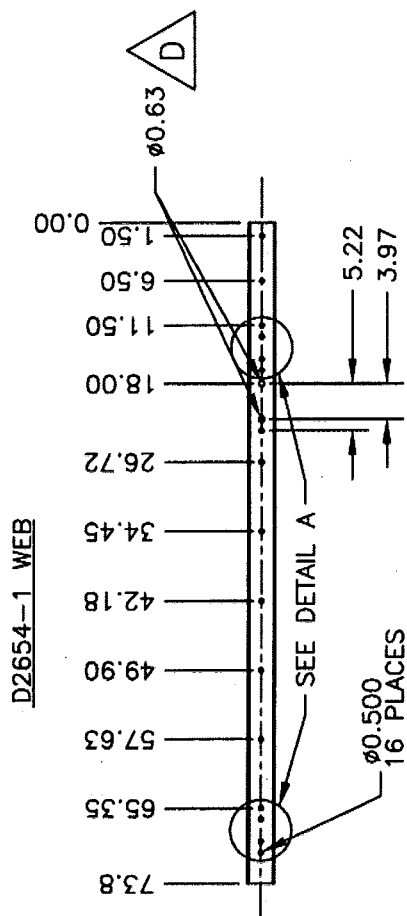
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO Ø0.63	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1 	04.08.04	PER TOOLING; Ø0.8 WAS Ø0.5	

RELEASED
04.06.22



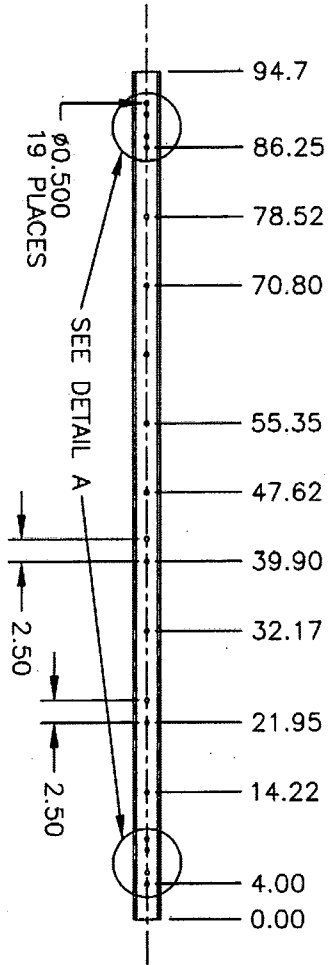
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RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 38746

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

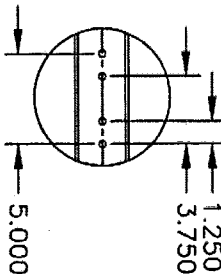
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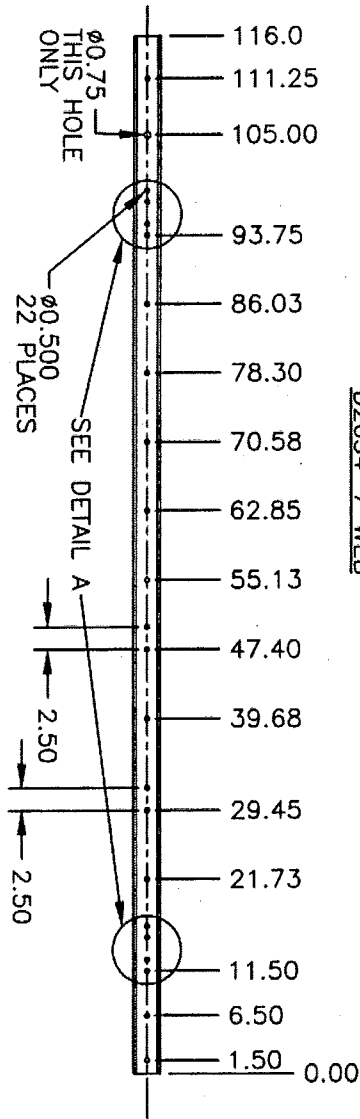
D2654-5 WEB



DETAIL A
 SCALE 1:10



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 WITHOUT NOTICE
 WORK ORDER
 NO. 58746

RELEASED
 04.05.26

1:20	SCALE	SHEET 2 OF 2	REV. E	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	DRAWING NO. D2654	DATE 04.05.26	WEB	TITLE
DESIGN	CHECKED	APPROVED	D2654	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	DRAWING NO. D2654	DATE 04.05.26	WEB	TITLE
DRAWN BY	DESIGN	CHECKED	APPROVED	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	DRAWING NO. D2654	DATE 04.05.26	WEB	TITLE
1:20	SCALE	SHEET 2 OF 2	REV. E	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	DRAWING NO. D2654	DATE 04.05.26	WEB	TITLE